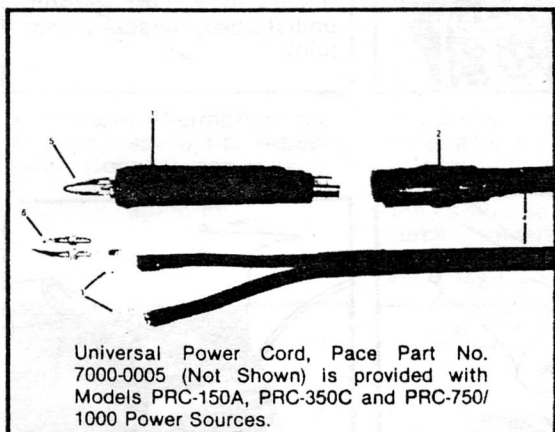


How To Use Your Mult. Purpose Thermal Part / Lap Reflow Soldering Pulse Heat Probe Model TP-20-02 LF-15-02

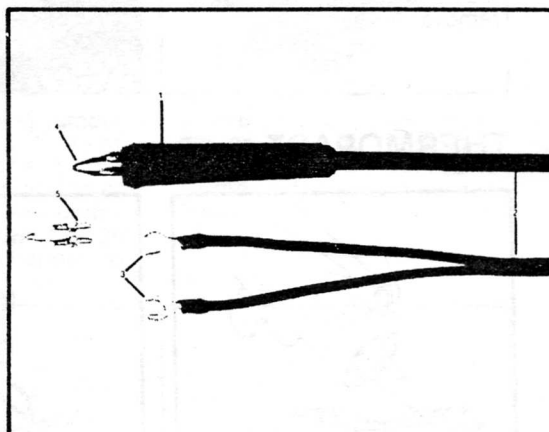
Parts Identification



Model LF-15-02

Pace Part No. 7013-0004-02

1. Molded Hand Piece
2. Universal Connector
3. High Current Power Connectors
4. Cord Universal Pace Part No. 7000-0023
5. Thermo Part Tip, Heavy Duty, Pace Part No. 6000-0009
6. Lap Flo Tip, Pace Part No. 6000-0008



Model TP-20-02

Pace Part No. 7022-0004-02

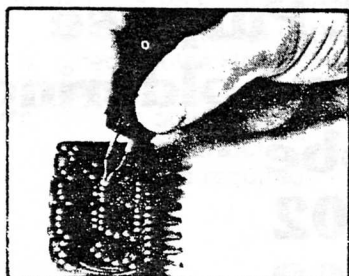
1. Molded Hand Piece
2. Heavy Duty Conductor Cord
3. High Current Power Connectors
4. Thermo Part Tip Pace Part No. 6000-0050
5. Lap Flo Tip, Pace Part No. 6000-0025
6. Thermo Part Tip, Heavy Duty Pace Part No. 6000-0009 (Not shown)

Set-Up

See Set-up Procedure and Heat Application Chart in Your Power Source Operation and Maintenance Instruction.

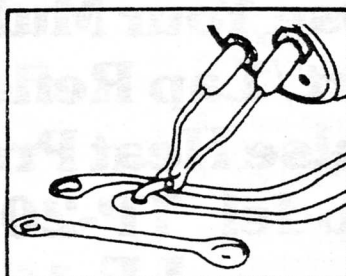
Use Foot Pedal Control for Timing Heat Cycle.

FUNCTION TOOL OPERATION

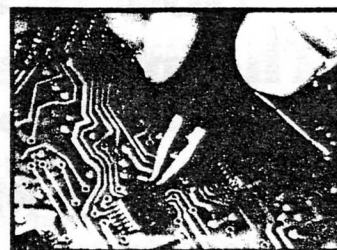


ThermoPart

Epoxy conformal coating removal. Application of controlled heat via alloy tip thermally degrades conformal coating for fast, safe removal.



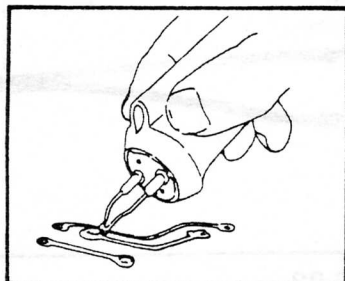
Clinched D.I.P. and other difficult to handle leads can be easily and safely unclinched.



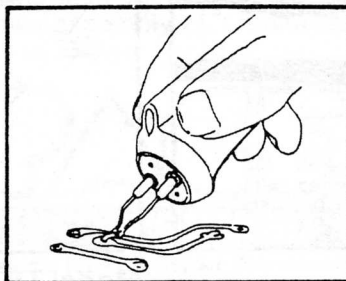
LapFlo

LapFlo soldering flat pack. Steady pressure is applied to work through the LapFlo soldering operation. This results in a thin, uniform, undisturbed, reliable planar joint.

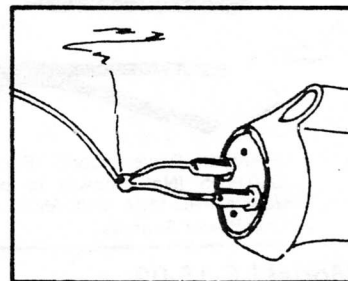
THERMOPART



1. Connect Power and adjust Heat. Locate tip for unclenching. Apply heat.

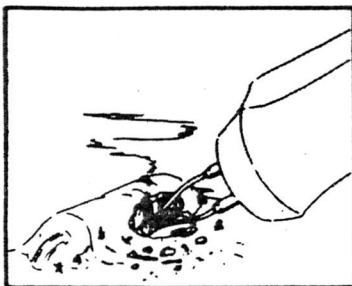


2. The ThermoPart tip unclenching lead. Heat until solder melts, lift lead from surface. DO NOT PRY or Pad will lift.

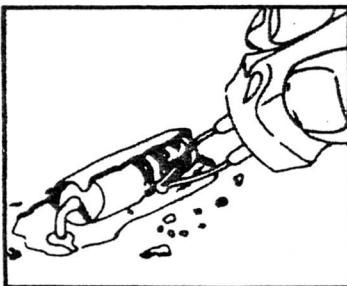


3. Adjust heat for scorchless operation. Proper temperature for epoxy removal will just melt solder held against heated tip. Use this method as an aid for heat setting selection.

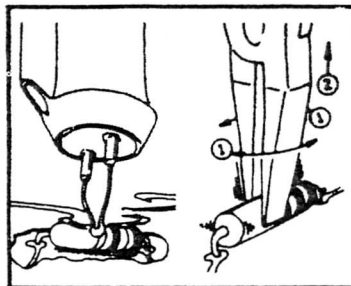
Set-Up



4. Apply tip to coating with light pressure, depress foot switch. Epoxy should granulate, Poly-U soften. Pulse heat for fine control.

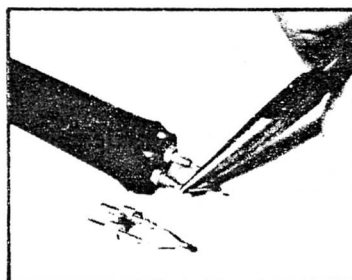


5. Remove bulk of coating around component. Use slow, rubbing motion. Don't go too deep. Extract solder.

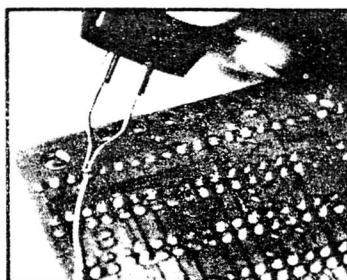


6. To soften bond, apply increased heat to component body. Twist and lift the component free. Clean up under component carefully.

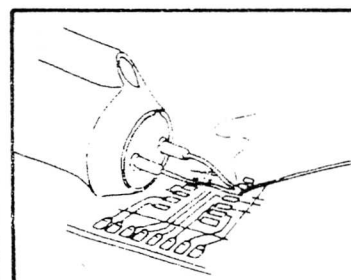
LAPFLO



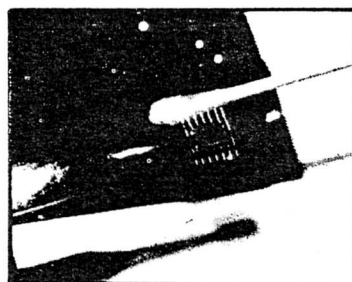
1. Remove ThermoPart tip. Plug in LapFlo tip. Adjust heat. Connect power cord. CAUTION! High heat will damage LapFlo tip.



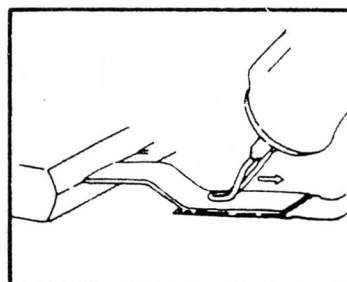
2. LapFlo soldering jumper in place on multilayer printed circuit board. The Heating/Clamping action of the LapFlo tip allows undisturbed soldering of No. 26 Teflon-insulated jumper to D.I.P. lead.



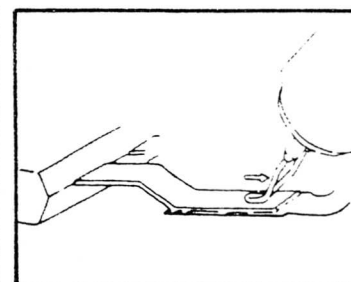
3. Pre-Tin pad. Position solder on pad. Tip on solder. Depress foot switch. Remove tip when solder flows.



4. Component Preparation. Apply flux to pads and lead. Pre-position component.



5. Solder Component in place. Place tip on lead. Depress foot switch. Slide tip 1/64" to 1/32" towards end of lead when solder flows.



6. Release foot switch. Hold tip motionless with light pressure on lead until solder cools.

MAINTENANCE AND TROUBLE SHOOTING

1. Keep the tip clean. Use abrasive paper and solvent.
2. No power at low voltage A.C. receptacles with heat ON.
 - a. Is main Power Cord connected to an operational outlet?
 - b. Check Pulse Heat Control Fuse. Replace as required.
 - c. Still no power? Check Pulse Heat Temperature Controller. Replace as required.

OPERATION TIPS

1. Start cool on unfamiliar materials.
2. Tips are always in contact with work before heating.
3. Increase heat a little at a time.
4. Pulse the foot switch for heat fine control.
5. Watch for damage indicators. Discoloration, scorching, smoke.
6. Stop heat before damage occurs. Practice.
7. Try to set-up on scrap to get a feel for the material.
8. For operator safety and to prevent tip damage, always turn control dial knob to OFF position before connecting ThermoPart/LapFlo tool.

HEAT APPLICATION NOTES

- How much temperature and time is required for each of the endless operations your Pulse Heat Function Tools can perform?

Only your skill and experience on your own assembly and repair operations can answer this question.



Systems for PCB Repair Anywhere™

9893 Brewers Court
Laurel, Maryland 20723 - U.S.A.

Tel. (301) 490-9860

Fax (301) 498-3252

©1980 PACE Incorporated all Rights Reserved. Printed in the U.S.A.
All specifications subject to change without notice.